

DART AEROSPACE LTD		Work Order:	
Description: MID HEIGHT AFT CROSSTUBE		Part Number:	D135-1027-253
Inspection Dwg: D135-1027-253 Rev: B			Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.550" TYP	+/-0.005"					
8.23" TYP	+/-0.030"					
12.08" TYP	+/-0.030"					
2.19" REF	+/-0.030"					
3.13" TYP	+/-0.030"					
Ø.194" THUR 2PL	+0.006" -0.001"					
Ø.194" THUR	+0.006" -0.001"					
17.0" 2PL	+/-0.100"					
Ø.313" THUR 6PL	+0.006" -0.001"					
Ø.670" THUR 2PL	+0.006" -0.001"					

WALL THICKNESS MEASUREMENTS

LOCATION FROM CL	DWG DIM	R1	R2	R3	R4				
CL	0.197"								
21"	0.197"								
21"	0.197"								
CENTER OF BEND	0.197"								
CENTER OF BEND	0.197"								

OUTSIDE DIAMETER MEASUREMENTS

LOCATION	DWG DIM	M1	M2				
CL	3.543"						
CENTER OF BEND	3.543"						
CENTER OF BEND	3.543"						

CRUSHING

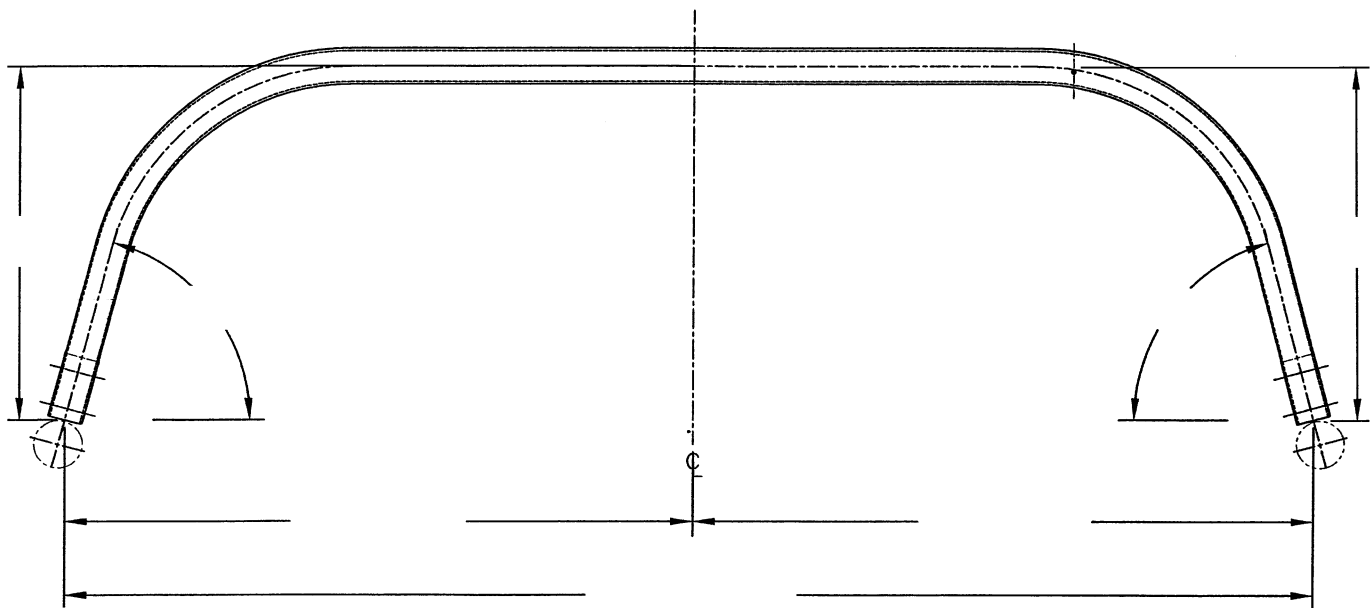
	SIDE A	SIDE B
MAX 2%		

TWIST

	SIDE A	SIDE B
MAX 0.25"		

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Required Dimension	Min	Max
Height	16.87"	17.13"
1/2 Span	40.28"	40.54"
Angle	64°	66°
Total Span	80.56"	81.08"
Bending Passes		
Crushing	0%	2%
Twist	0.0"	0.25"



Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	18/01/16	New Issue	ED	